

Date: Thursday, 19/02/2009 1:59:29 PM
 User: Julie Dawson

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BRACKET
Job Number	: 45911		
Estimate Number	: 13130		
P.O. Number	:	Part Number	: D36871
This Issue	: 19/02/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3687 REV B
First Issue	: / /	Project Number	: N/A
Previous Run	: 44683	Drawing Revision	: B
	Type : PURCHASED PARTS	Material	:
Written By	:	Due Date	: 03/03/2009
Checked & Approved By	: <u>JUL 09.02.19</u>	Qty:	5 Um: Each
Comment	: Est Rev:A New Issue 08-01-15 JLM Verified By:EC Est Rev:B Added Contion H-900 JLM Verified By:DD		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	OUTSIDE SERV.30	OUTSIDE SERVICES-MACH

**Comment:** Sub-Contracting OUTSIDE SERVICES-MACH

Sub-Contracting, Ship Material to Metcor

P/O: 8148 C209/02/24

Send M74B3937 x 4750 for Heat Treating
 to Condition H-900 (To become M174PHH900B3937 x 4750)
 FTU IN EXCESS OF 190 KSI
 FTY IN EXCESS OF 170 KSI
 Certificate Required

2.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASINGIssue P/O for D3687-3P P.O. 8266C209/02/24 (5)

Machine as per Dwg D3687 Rev. B

Possible Supplier: Globus Precision

Conformity sheet required

Ship to supplier:

M174PHH900B3937X4750 B 111100 C209/03/10

3.0	M174BH900 3937X4750	17-4SS Bar 3.937x4.750 COND.H900
-----	---------------------	----------------------------------

**Comment:** Qty.: 0.3500 F(s)/Unit Total: 1.3999 F(s)

17-4 SS Bar 3.937 x 4.750 CONDITION H-900

Batch: M111100

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 19/02/2009 1:59:29 PM
User: Julie Dawson

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET

Job Number: 45911

Part Number: D36871

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

D36871P

MOUNT



Comment: Qty.: 1.0000 Each(s)/Unit Total: 4.0000 Each(s)
MOUNT

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage
Ensure certificate of conformity is attached

6.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

7.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES-MACH
Issue P/O: 8537
LPI Per ASTM 1417 LEVEL 2
Certificate of conformaty is required

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: 123

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



2.2 attached cert

1/29/4/8 5

u 3-04-14

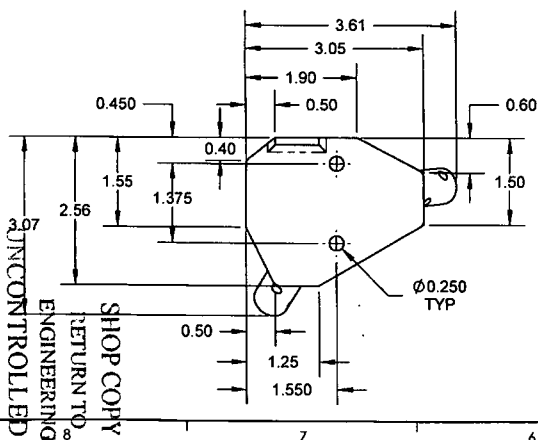
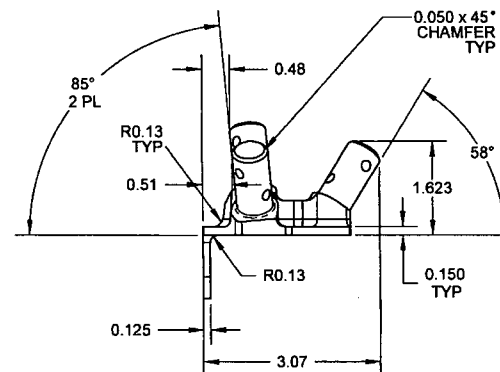
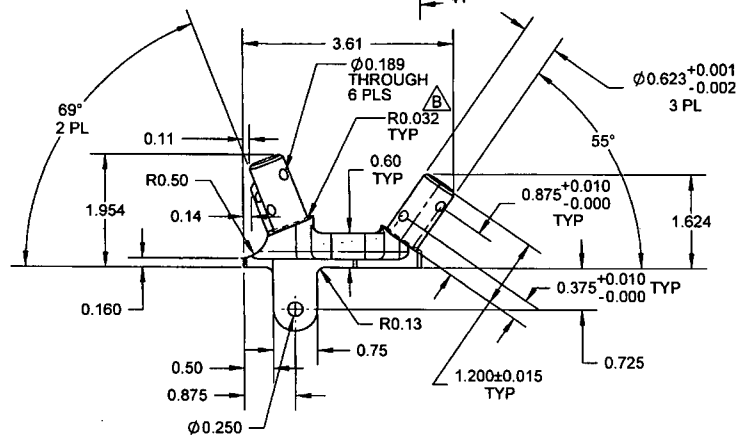
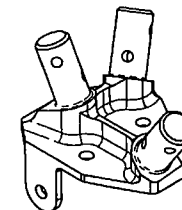
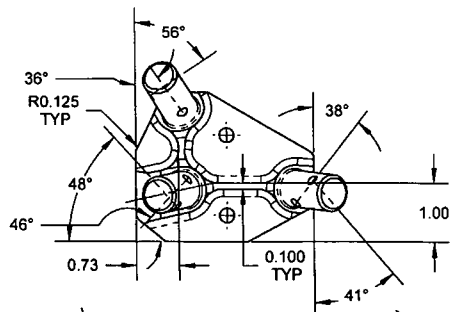
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3687-1 MOUNT



- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.81 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

RELEASED
08/12/15

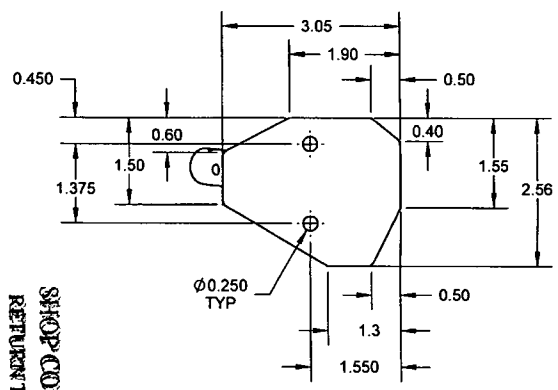
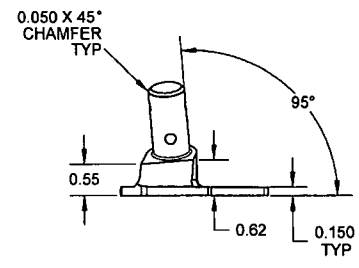
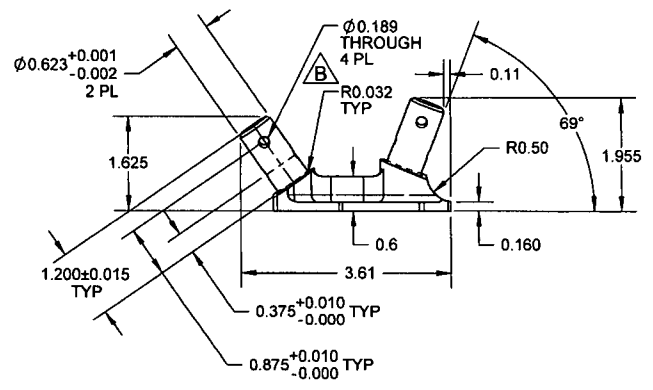
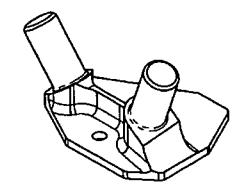
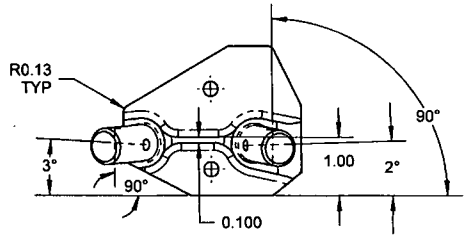
B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R0.032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV.	DESCRIPTION	BY	DATE
DESIGN	RF		
DRAWN	RF		
CHECKED	90		
MFG. APPR.	91		
APPROVED	92		
DE APPR.	93		
DATE	08.11.24		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3687** REV. B
SHEET 1 OF 2
TITLE **MOUNT** SCALE NTS

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WORK ORDER NO. 4591
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY



- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.64 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

RELEASED
08/12/15

D3687-3 MOUNT

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3687	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

NO. 445911
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

Certification

Order	Load
145892	1

Customer 215
 DART AEROSPACE
 1270 ABERDEEN
 HAWKESBURY

ON K6A 1K7

Shipped To:
 DART AEROSPACE
 1270 ABERDEEN
 HAWKESBURY

ON K6A 1K7

Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Mat'l Heat Code	Lot Number						
8148		17-4PH								
<p align="center"><u>PROCESSING SPECIFICATIONS</u></p> <p>AGE HARDEN CONDITION H 900 SAE AMS 2759/3 REV.E</p>										
Requirement	Specified	Tests Performed	Test Results							
HARDNESS	40 - 47 HRC	1	43 - 43 HRC							
Quantity	Weight	Part Number / Part Description								
1	320	PIECE NIL (PAS DE CONTENANT)								
Operation	Specified Temp	Specified Soak Time	Atmosphere	Carbon Potential	Q-Media Q-Temp	Furnace# Load #	Start Date	Time In	Time Out	Date Complete
1.00 CONT. INIT.	LAVAGE		si nécessaire							
2.00 PREPARING	COMPTAGE									
3.00 AGE HARDE	900 +/-10°F	1 hrs -0 +3 MIN	air			635	03-02-09	8:35	13:20	03-02-09
4.00 HARDN INS										
5.00 FINAL INSP										03-06-09

COMMENTS

APPROVED BY:

BIB

DATE: 2009-03-06

We certify that all the information on this report is exact and in accordance with the order requirements. / Nous certifions que toute l'information comprise sur ce rapport est exacte et conforme aux requis du client.



Magna Stainless
5775 Kieran St, Saint-Laurent, Quebec H4S 0A3
Phone: (514) 631-1211 Watts: 1-800-363-6646 Fax: (514) 339-1105

PACKING LIST

I006996

Page: 1 of 1

SOLD TO:
DART AEROSPACE LTD
1270 ABERDEEN STREET

HAWKESBURY , ON
K6A 1K7
Contact: CHANTAL

SHIP TO:
METCOR
560 ARTHUR SAUVE
SAINT EUSTACHE
SAINT-EUSTACHE, QC
J7R 5A8

Ship Terms: PREPAID

MTR:Y

SPECIAL INSTRUCTIONS

Currency		Sales Person		Customer Phone	Customer Fax	Customer PO	
CANADIAN DOLLARS		ERYCK BLAIS		(613) 632-5200	(613) 632-1053	7996	
Sales Order	Terms		Ship Via		Date Ordered	Date Required	Date Shipped
W007493	NET 30 DAYS		NIR:R-557065-1		02/05/09	02/11/09	02/13/09

Ordered	Back Ordered	Unit	Description	Bundle #	Heat #	Shipped
312		LB	17-4 PH 3.937 X 4.7500 X 5" CUT 312 LB / 1 PC	L022189	253518 36279	312 312
skids: 1			Total Weight:		312 LB	

Received by:

S.T. Laurent

Date:

Signature:



MILL CERTIFICATE OF QUALITY

ORD 5049 1.1.D
RE 1024 1.1.D

PRINTED 08.10.02.2006
NUMBER: 212011 REV 000
SHEET: 1 / 2
DATE: 10.02.2006

PURCHASE ORDER: AC0835

ASTM A 36
ASTM A 65

GRADE: Y100

QAD 49 REV. 3

OUR REFERENCE: 22198

MATERIAL SPECIFICATION: QAD 49 REV. 3

PURCHASE METHOD: BASIC ELECTRIC FURNACE + A.O.D

SIZE
150MM SQ
300MM SQ

4.000 / 1.000 MM

1.000 / 1.000 MM

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SURFACE FINISH

ITEM 2 FULLY SURFACE GROOVED

ITEM 3 FULLY SURFACE GROOVED

ITEM 4 FULLY SURFACE GROOVED

ITEM 5 FULLY SURFACE GROOVED

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ITEM 50 FULLY SURFACE GROOVED

UTTERMOST TESTED ACCORDING TO

ITEM	CLASS	STANDARD
1	2	A-36/A-715 Q12
2	3	A-36/A-715 Q13

SPECIFICATION CHECKED BY
TONY HARRISON AND IS IN
ACCORDANCE WITH OUR
PURCHASE ORDER

DATE REGISTERED

01/11/06

ACERALAYA
ACERIA DE ALAVA S.A.
Director de Calidad e I+D

Javier Valle Edwards




Invoice

36 Colonnade Road N.
Ottawa, Ontario K2E 7J6
Tel: (613) 226-1579
Fax: (613) 226-1719

DATE	INVOICE NO.
3/30/2009	17518

BILL TO	SHIP TO
Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7	Main Finished Goods Location Dart Aerospace 1270 Aberdeen Street Hawksbury, Ontario K6A 1K7

P.O. NO.	TERMS	SHIP DATE	SHIPPED VIA	JOB NO.	FOB
00008266	Net 30 Days	3/30/2009	FedEx	902	Globus

QTY	DESCRIPTION
5	D36871P Rev. B Mount Business Number: 102122058 <i>Selalos</i> 

WHITE = Original
BLUE = C of C
YELLOW = Packing Slip

Carrying Charge - 2% per Month -24% per Annum
on Overdue Accounts



LIQUID PENETRANT TEST REPORT

P - 1369 2

CLIENT	DART AEROSPACE	DATE	APR 8, 2009	PAGE	1	OF	1
ATTENTION	LINDA LACELLE	ACUREN JOB No.	188 09 1369	TIME	AM <input type="checkbox"/>	PM <input type="checkbox"/>	
ADDRESS	1270 ABERDEEN ST	PO/VO No.					
	HAWKESBURY, ONT.	WORK LOCATION	HAWKESBURY				
		ACCEPTANCE STD.	ASTM 1417/QSI-038	REV./DATE	2005		
PROJECT	BRACKETS AND STUDS						
ITEM(S) EXAMINED	JOB #'S 44684,45911,45912,46052						

JOB DESCRIPTION	PROCEDURE No. LT-0002	REV./DATE	TECHNIQUE No. LT-TECH2	REV./DATE
PART No. D36873/D36871/D36873/D36911	MATERIAL	THICKNESS		
SCOPE	WET FLOURESCENT LIQUID PENETRANT INSPECTION CARRIED OUT ON 100% EXTERNAL SURFACE			

TEST DETAILS

METHOD	<input checked="" type="checkbox"/> FLUORESCENT	<input type="checkbox"/> VISIBLE	<input checked="" type="checkbox"/> WATER WASH	<input type="checkbox"/> SOLVENT REMOVABLE	<input type="checkbox"/> POST EMULSIFIED
FAMILY BRAND	MAGNAFLUX		BLACK LGHT8171	<input checked="" type="checkbox"/> OUTPUT > 1000 μ W/cm ²	<input type="checkbox"/> AMBIENT < 2 fc
PENETRANTZL67	MINIMUM DWELL TIME	45 MIN.	LIGHTING EQUIP.	<input type="checkbox"/> FLASHLIGHT	<input type="checkbox"/> TROUBLELIGHT
PENETRANT REMOVER H2O	MINIMUM DRY TIME	>10 MIN.	OTHER	CAL JAN 24 09	
DEVELOPER SKDS2	MINIMUM DWELL TIME	10 MIN.	LIGHT METER S/N	CAL DUE DATE	
DEVELOPER TYPE	<input checked="" type="checkbox"/> NON AQUEOUS	<input type="checkbox"/> AQUEOUS	<input type="checkbox"/> DRY		

TEST SURFACE

SURFACE CONDITION	<input type="checkbox"/> AS GROUND	<input type="checkbox"/> AS WELDED	<input type="checkbox"/> MACHINED	<input type="checkbox"/> SHOT BLASTED	<input checked="" type="checkbox"/> CLEAN BARE METAL
SURFACE TEMPERATURE	<input type="checkbox"/> < -4°C/ 20°F	<input type="checkbox"/> - 4°C/ 20°F TO 10°C/50°F	<input type="checkbox"/> 10°C/50°F TO 52°C/125°F	<input type="checkbox"/> > 52°C/125°F	

RESULTS- ☐ METRIC ☒ IMPERIAL

FLUORESCENT LIQUID PENETRANT INSPECTION

CARRIED OUT ON 100% EXTERNAL

SURFACE ON:

44684- 6 BRACKETS

45911- 5 BRACKETS

45912- 4 BRACKETS

46052- 19 STUDS

RESULTS: NO INDICATION OF DEFECTS.

ITEMS ACCEPTABLE TO STANDARD

Scope of Services
The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner operator and the owner operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care
In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE		DTR # E 27430	
TECHNICIAN (SIGNATURE):		REPORT REVIEWED BY:	
NAME (PRINT):	JASON HEWETT	NAME INITIALS	
	1 st TECHNICIAN	2 nd TECHNICIAN	
CGSB LEVEL	2	CGSB LEVEL	SNT LEVEL
CGSB REG. No	6156	CGSB REG. No	

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY